



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2873-045
Job Sheet 173682



Part No: D2873-045

Job Qty: ~~25~~ ea ²²
J.C.C.

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	25 Ea		3/15/18	0.00	0.00	Start Up Machining-1		18/03/13
100	Bandsaw	25 pcs		3/15/18	0.00	0.22	Bandsaw1		AS 18/03/13
110	CNC Vertical Machining	25 pcs		3/15/18	0.09	6.35	HAAS1-2		12 18/03/13
120	QC	25 pcs		3/15/18	0.00	0.00	QC2 Machining-1		89 18/03/13
130	QC	25 pcs		3/15/18	0.00	0.00	QC8 Machining-1		18/03/13
140	Small Fab	25 pcs		3/15/18	0.00	0.70	Small Fab-2		DAS 38
150	QC	25 pcs		3/15/18	0.00	0.00	QC5		SA 18-03-20
160	HandFinish	25 pcs		3/15/18	0.00	0.51	HandFinish1		18-03-22
170	QC	25 pcs		3/15/18	0.00	0.00	QC7-1		18-03-22
180	Small Fab	25 pcs		3/16/18	0.00	0.70	Small Fab-2		18-03-22
190	QC	25 pcs		3/16/18	0.00	0.00	QC5		18-03-22
200	Packaging	25 pcs		3/16/18	0.00	0.00	Packaging3-1 LG 050		18-03-22
210	QC21-SA	25 Ea		3/16/18	0.00	0.00	QC21		18-03-22

Part Op 100 - Cut blanks: 1.000" x 0.375" x 2.700" long

Descriptions: 110 - Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev ____ F1819Folio Rev ____

140 - 1-Deburr

180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-045

200 - LOCATION : LG050

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X01.000	6061-T6 Bar .500 X 1.00	5.6250 ft (.225 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	100 Ea (4 ea)	180-Small Fab	
MS21075L5	Nut Plate	50 Ea (2 ea)	180-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X01.000	6	10	0
180-Small Fab	MS20426AD4-6	100	1,320	0
	MS21075L5	50	374	0

6033411

Part Specifications

3X 1X-375 FM138152-40-75ft.

5x 22411 12x 1.25X.375 4.95

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small Fah ☐ Water Jet ☐ Engineering ☐ Coord. gling ☐ Quality ☐ Other ☐																																						
Date : _____		Step #: _____		MRB (QSI042) Approval 																																						
Description Work Order Deviation 						Completed By 																																				
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Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td rowspan="2">OTHER : ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>						Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐	Misidentified ☐	Past Due ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Date: 03/13/18

Inspector: _____

Revision: _____

Serial No/Batch: S050682

Job No: 173682

Part: D2873 - 045

Container No: S050682

DART AEROSPACE

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Specifications could not be found.

Plex 3/6/18 12:50 PM Dart.lejeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	173682
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.502	✓		Ver	
1.000	+/-0.010	1.000	✓		Ver	
0.750	+/-0.010	.749	✓		Ver	
0.250	+/-0.010	.250	✓		Ver	
1.000	+/-0.010	1.000	✓		Ver	
2.000	+/-0.010	2.000	✓		Ver	
Ø0.128	+0.005/-0.001	Ø.128	✓		Ver + G.P.	
0.359	+/-0.010	.359	✓		Ver + G.P.	
Ø0.316	+0.006/-0.001	Ø.316	✓		G.P.	
1.000	+/-0.010	1.001	✓		Ver	
0.250	+/-0.010	.248	✓		Ver	
0.061	+/-0.010	.062	✓		Ver	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .125			G.P. + Ver	

Measured by: DAS 52	Audited by: [Signature]	Prototype Approval:	N/A
Date: 18/03/13	Date: 18/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	[Signature]

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